

# Work Order ID 53001

October 20, 2009 3:22:38 PM



Page 1

Item ID: D3990-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Cable Guard

Start Date: 10/20/09 Start Qty: 4.00



Cust Item ID:

Required Date: 10/23/09 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3990

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per File d3990-1-blank

B 9-10-21

(PB)

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA845

Folio Rev:

Dwg Rev: A

Deburr as per Dwg

3

1

8/09/10/28

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3990-1 PAR #:            Fault Category: machined parts NCR: Yes No DQA:            Date: 05-11-18  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed:            Date: 05-11-18

NCR: 53001		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
02/01/02	#140	Part was placed in wrong orientation Re. Crack attention	CP 05.11.02 per 05/11/02	Scrap and Dastar No Replace	LS 02/11/05	S 02/11/02	CP 05.11.02 per 05/11/02	S 02/11/02
		Part was placed Backwards Section BB was in EE	CP 05/11/02					S 02/11/02

NOTE: Date & initial all entries

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Item ID: D3990-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Cable Guard

Start Date: 10/20/09 Start Qty: 4.00



Cust Item ID:

Required Date: 10/23/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00	SB 09/10/28			3	1		
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	JK 09/11/06						
140  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00 0.00	9/11/9 (3x) SP						

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Item ID: D3990-1

Accept

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Required Date: 10/23/09 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/11/11

MF  
09-11-10

# Picklist Print

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Page 1

Work Order ID: 53001



Parent Item: D3990-1RevA



Parent Item Name: Cable Guard

Start Date: 10/20/09

Required Date: 10/23/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MUHMWB1750X1000 X4800		Purchased	No			100	sf	0.0000	7.3684			
										9-10-21		
UHMW 1.75x1.00x48.00												

110721

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 53001
<b>Description:</b> Cable Guard		<b>Part Number:</b> D3990-1
<b>Inspection Dwg:</b> D3990	<b>Rev:</b> A	<b>Page 1 of 2</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

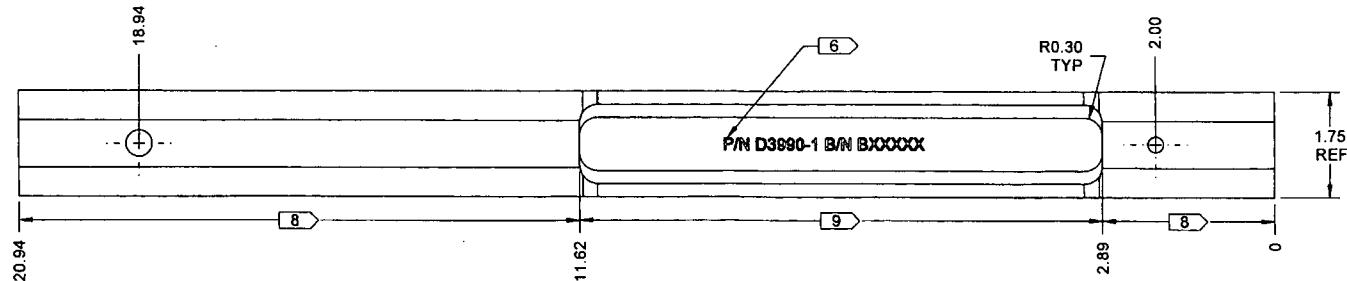
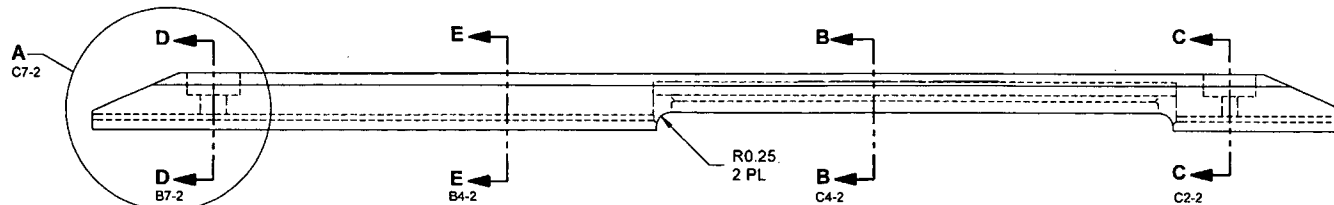
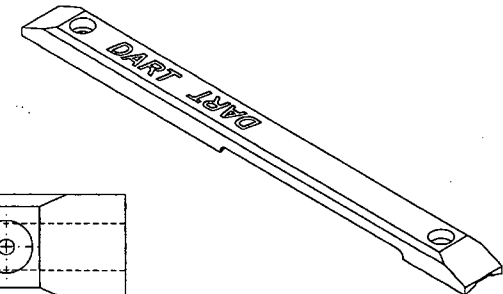
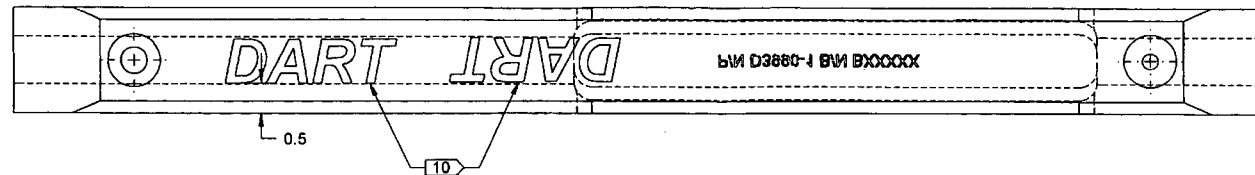
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
20.94	±.030	20.94	✓			
11.62	"	11.62	✓			
2.89	"	2.870	✓			
1.75	Ref	1.760	✓			
2.00	±.030	1.985	✓			
13.94	"	13.941	✓			
.5	"	.505	✓			
.65	"	.65	✓			
.88	"	.884	✓			
1.31	"	1.309	✓			
.14	"	.145	✓			
.36	"	.367	✓			
.10	"	.110	✓			
Ø.875	±.010	.885	✓			
.370	"	.365	✓			
.95	±.030	.944	✓			
.70	"	.680	✓			
.78	"	.790				
Ø.261	+ .006 - .001	.261	✓			
Ø.375	±.010	.385				
.370	"	.365				
.700	±.030	.690				
.95		.946				

<b>Measured by:</b> <i>LF</i>	<b>Audited by:</b> <i>JK</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/10/24	<b>Date:</b> 09/11/06	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



W/ 53001



**D3990-1 CABLE GUARD**

**RELEASED**  
2009-09-10

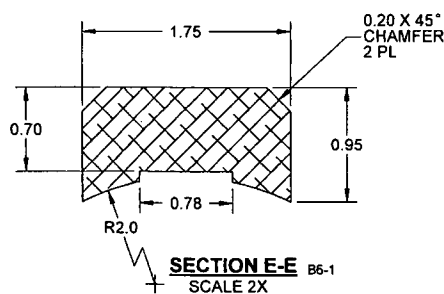
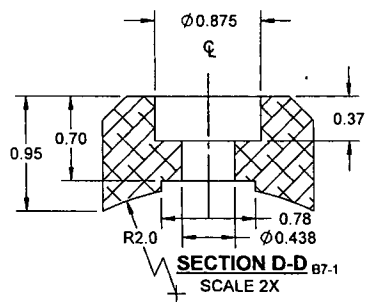
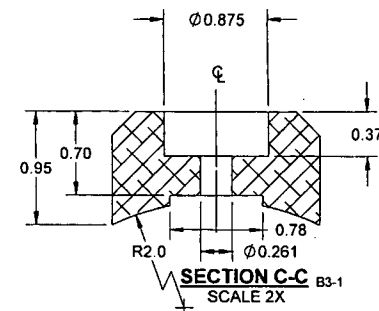
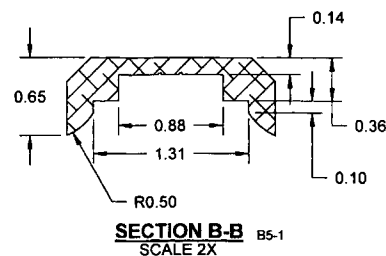
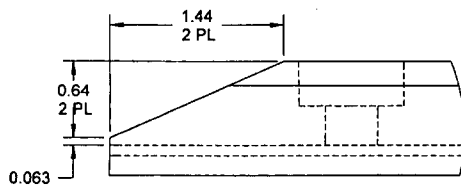
**NOTES:**

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL PER SPEC CONTROL DWG D2689
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3990-1" AND B/N TO MAX DEPTH OF 0.015 AND MIN TOOL TIP RAD 0.25
- 7) WEIGHT: 0.63 lbs
- 8) MACHINE CONSTANT SECTION E-E, EXCEPT FOR DETAIL A
- 9) MACHINE CONSTANT SECTION B-B, EXCEPT FOR TRANSITIONS
- 10) ENGRAVE "DART" LOGO ON UPPER SIDE TO MAX DEPTH OF 0.015 AND MIN TOOL TIP RAD 0.25, 2 PL







A		NEW ISSUE		09.08.28	
REV.		DESCRIPTION		BY DATE	
DESIGN		<div>DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA</div> <div>D3990</div> <div>CABLE GUARD</div> <div>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</div>			
DRAWN					
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.		REV. A SHEET 1 OF 2 SCALE NTS			
DATE		09.08.28			



W/S 53001



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2009-08-10

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3990	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CABLE GUARD	NTS
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